

Work Order ID 85723

June-14-12 10:51:24 AM

85723

Page 1

SHIP July 3

Item ID: D3913-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Long Basket Base Assembly, 350

Start Date: 14/06/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 02/07/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/06/14

Tooling:

Date:

Run Start ***NR1***

QC: Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3913

A

D4020

A

100 Weld per dwg A/R S.S. rod Batch: M118161 0.00

100

Large Fab

Large Fab

Memo

0.00

1- assemble ribs , weld as per dwg D3913 using DT9610A
 inspect before welding mesh
 2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913
 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends
 3- weld hinge (3) and Mounting brackets as per dwg D3913
 take lid to locate hinge and bracket

CC 12-7-3

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Quality Control

Memo

0.00

Pl 12.07.03

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Date:

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Date:

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QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

125

Pressure Wash per QSI005 4.3

0.00

125

HandFinish

Memo

0.00

Hand Finishing

1 ϕ 12-3.

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> Other <input type="checkbox"/> </div> <div> Engineering Quality <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Offset/Setup											
Other											
Process											
Supplier											
Training											
Unauthorized											

FAULT CATEGORY									
Landing Gear			Hardware			General			
<input type="checkbox"/> Bending Passes Below Min	<input type="checkbox"/> Breaking	<input type="checkbox"/> Burrs	<input type="checkbox"/> Maintenance	<input type="checkbox"/> Set-up					
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> Missing	<input type="checkbox"/> Contamination	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Supplier					
<input type="checkbox"/> Cracks	<input type="checkbox"/> Size/Length	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Off-Set	<input type="checkbox"/> Temperature/Cure					
<input type="checkbox"/> Crushed/Crimp at Bending	<input type="checkbox"/> Spinning	<input type="checkbox"/> Documentation/Data	<input type="checkbox"/> Orientation Misread	<input type="checkbox"/> Weld					
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Threading	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration	<input type="checkbox"/> Wrong Stock Pulled					
<input type="checkbox"/> Other	<input type="checkbox"/> Wrong	<input type="checkbox"/> Inspection Incomplete	<input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Other					
<input type="checkbox"/> Positioned Wrong	Drill Holes		<input type="checkbox"/> Outside Dimensions						
<input type="checkbox"/> Ripples on Inner Bend	<input type="checkbox"/> Misaligned	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Over/Under tolerance						
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Ovalized	<input type="checkbox"/> Jigs/Fixtures/Tooling	<input type="checkbox"/> Part Lost						
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Over/Undersized	<input type="checkbox"/> Kit Incorrect	<input type="checkbox"/> Part Moved						
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Too Many	<input type="checkbox"/> Kit Missing	<input type="checkbox"/> Raw Material						

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Item ID: D3913-041

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N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

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Start Date: 14/06/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 02/07/2012 Req'd Qty: 1.00

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

130

Powdercoat

Powder Coating

Memo

0.00

1- Plug holes and mask only interior of hinge (3) prior to powder coat

1ST COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

***** 2nd coat if necessary*****

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

140

QC3- Inspect Part Finish

0.00

140

QC

Quality Control

Memo

0.00

IX 0 12/07/03

1 0 12-74

M121841

2:30
400 OF

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85723

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Item ID: D3913-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Long Basket Base Assembly, 350

Stop ***NS2***

Start Date: 14/06/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 02/07/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Assemble as per dwg	0.00							
150									
HandFinish	Memo	0.00							
Hand Finishing	Pick Kit								
160	QC5- Inspect part completeness to step on W/O	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Locations	0.00							
170									
Packaging	Memo	0.00							
Packaging									

1 0 PR 12-7-4.
12/07/03 JB

512/07/04

D4030-041

85722

1 0 PR 12-7-4.

Picklist Print

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Work Order ID: 85723

85723

Parent Item: D3913-041

D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 14/06/2012

Required Date: 02/07/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2581		Manufactured	No			100	Each	43.0000	2	2			
D2581									**				
Mounting Bracket													

Location

Loc Qty

Loc Code

WA

5

82506

2

83230

3

WA005

38

70766

2

81253

1

82897

35

385436 SJ 12.07.03

(2x)

D3913-1

Manufactured No

100

Each

1.0000

1

1

D3913-1

Rib

**

382913 SJ 12.07.03

Location

Loc Qty

Loc Code

WA

1

74145

0

80790

1

(1x)

D3913-15

Manufactured No

100

Each

8.0000

1

1

D3913-15

Wide Handle Plate

**

SJ 12.07.03

Location

Loc Qty

Loc Code

WA

3

85438

3

WA005

5

82919

5

(1x)

Picklist Print

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Work Order ID: 85723

85723

Parent Item: D3913-041

D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 14/06/2012

Required Date: 02/07/2012

Start Qty: 1.00

Required Qty: 1.00

D3913-3 Manufactured No

100 Each 5.0000 1 1

D3913-3

Rib

**

dy 12.07.03

Location

Loc Qty

Loc Code

WA

4

69160

0

74144

0

82920

3

84651

1

WA006

1

69160

1

1x

D3913-7 Manufactured No

100 Each 13.0000 2 2

D3913-7

Rib

**

dy 12.07.03

Location

Loc Qty

Loc Code

WA

13

83908

1

85440

12

2x

D3913-9 Manufactured No

100 Each 9.0000 1 1

D3913-9

Hinge Rib

**

dy 12.07.03

Location

Loc Qty

Loc Code

WA

8

84814

3

85292

5

2 1x

WA006

1

70138

1

June-14-12 10:51:28 AM

Shop Packet Print

Page 2

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube <input type="checkbox"/></td> <td style="width:15%;">Crosstube <input type="checkbox"/></td> <td style="width:15%;">Prod. Eng. Coord. <input type="checkbox"/></td> <td style="width:15%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Supplier <input type="checkbox"/>		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Other <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Supplier <input type="checkbox"/>																
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Other <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Offset/Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unauthorized <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending Passes Below Min <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimp at Bending <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Other <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Ripples on Inner Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	Hardware <input type="checkbox"/> Breaking <input type="checkbox"/> Missing <input type="checkbox"/> Size/Length <input type="checkbox"/> Spinning <input type="checkbox"/> Threading <input type="checkbox"/> Wrong Drill Holes <input type="checkbox"/> Misaligned <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Undersized <input type="checkbox"/> Too Many	General <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Documentation/Data <input type="checkbox"/> Finish <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Inspection Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Jigs/Fixtures/Tooling <input type="checkbox"/> Kit Incorrect <input type="checkbox"/> Kit Missing	<input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Off-Set <input type="checkbox"/> Orientation Misread <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Lost <input type="checkbox"/> Part Moved <input type="checkbox"/> Raw Material <input type="checkbox"/> Set-up <input type="checkbox"/> Supplier <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
---	--	---	---

Picklist Print

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Work Order ID: 85723

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly. 350

85723

D3913-041

Start Date: 14/06/2012

Required Date: 02/07/2012

Start Qty: 1.00

Required Qty: 1.00

D3916-041

Manufactured No

100

Each

5.0000

2

2

D3916-041

Rib Assembly

**

385714 → 1x SJ 12.03.03

Location

Loc Qty

Loc Code

WA

2

84383

2

WA006

3

81444

2

85329

1

D3916-5

Manufactured No

100

Each

15.0000

3

3

D3916-5

Light Rib

**

B85777 → 2x SJ 12.07.03

Location

Loc Qty

Loc Code

WA

15

77142

1

82933

6

82934

8

D4016-1

Manufactured No

100

Each

13.0000

3

3

D4016-1

Hinge Half, Base

**

SJ 12.07.03

Location

Loc Qty

Loc Code

WA

13

66418

0

84867

13

3x

Picklist Print

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Work Order ID: 85723

85723

Parent Item: D3913-041

D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 14/06/2012

Required Date: 02/07/2012

Start Qty: 1.00

Required Qty: 1.00

D4021-1 Manufactured No

100 Each 9.0000 3 3

D4021-1

Handle Plate

**

B85652 *SY 12.07.03*

Location

Loc Qty

Loc Code

WA

9

69518

0

74316

0

74946

0

85439

9

(3X)

D4034-041 Manufactured No

100 Each 3.0000 1 1

D4034-041

Aft Upper Rib Assembly

**

SY 12.07.03

Location

Loc Qty

Loc Code

WA006

3

81435

3

1x

D4034-043 Manufactured No

100 Each 3.0000 1 1

D4034-043

Fwd Upper Rib Assembly

**

SY 12.07.03

Location

Loc Qty

Loc Code

WA

3

81174

2

1x

83756

1

Picklist Print

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Work Order ID: 85723

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

85723

D3913-041

Start Date: 14/06/2012

Required Date: 02/07/2012

Start Qty: 1.00

Required Qty: 1.00

M304EX0.75-16F

Purchased

No

100

sf

713.4864

33

33

M304FX0 75-16F

Expanded Metal Flat SS

**

4122.138 12.07.03
33.000

Location

Loc Qty

Loc Code

WA

4.9094

121738

4.9094

WA035

708.5769637

117197

102.9036

120917

101.57273

121521

0.00013372

121849

184.1005

122080

320

AN3-10A

Purchased

No

150

Each

139.0000

6

6

AN3-10A

Bolt

**

JB

Location

Loc Qty

Loc Code

GA

8

119084

8

ST351

131

117795

2

120873

129

120873

AN960JD8

NAS1149DN832

Purchased

No

150

Each

0.0000

2

2

AN960JD8

Washer

D2931

Manufactured

No

150

Each

410.0000

2

2

D2931

Bumper

**

120422

**

20

12/07/03 JB

Location

Loc Qty

Loc Code

ST504

410

46064

410

46064

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D3913-041

Start Date: 14/06/2012

Required Date: 02/07/2012

Start Qty: 1.00

Required Qty: 1.00

D4021-5 Manufactured No

150 Each 10.0000 2 2 ✓

D4021-5

Blanking Plate

** 1+85891 JB

Location

Loc Qty

Loc Code

ST083

2

84984

2

ST084

8

85065

8

1x 85065

MS20600-AD4W3 Purchased No

150 Each 740.0000 2 2 ✓

MS20600-AD4W3

Cherry Rivets

** 122151 JB

Location

Loc Qty

Loc Code

ST321

607

111636

36

117601

3

118626

310

120308

258

WA018

133

107939

133

MS21042L3 Purchased No

150 Each 1,748.000 6 6 ✓

MS21042L3

Nut

** JB 12/07/03

Location

Loc Qty

Loc Code

ST300

1748

115835

4

117885

32

119017

816

119075

138

121349

23

121444

735

121444

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D3913-041

Start Date: 14/06/2012

Required Date: 02/07/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

Purchased

No

150

Each

1,152.000

12

12

JB 12/07/03

NAS1149F0332P

WASHER

Location

Loc Qty

Loc Code

ST275

1152

117735

13

119225

10

120986

200

121259

200

121825

126

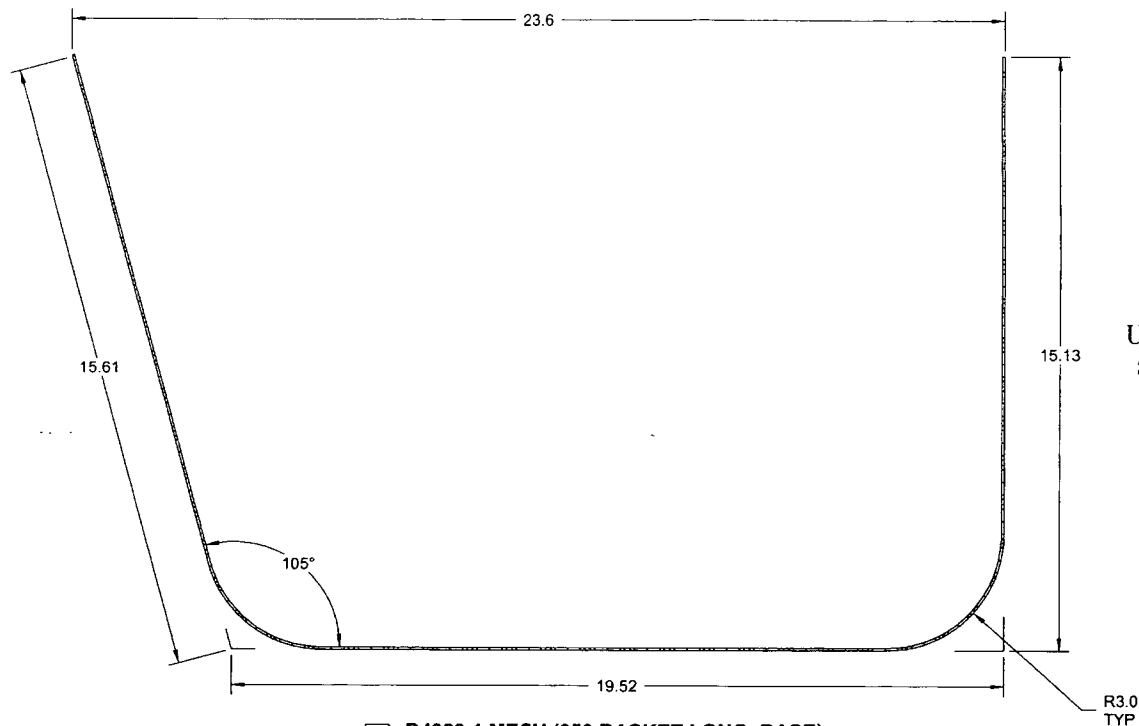
122063

600

17317

3

120986



9 **D4020-1 MESH (350 BASKET LONG, BASE)**
(SEE D4020-1F FOR LENGTH)

9 **D4020-3 (350 BASKET SHORT, BASE)**
(SEE D4020-3F FOR LENGTH)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 85723 MWS

12/06/14

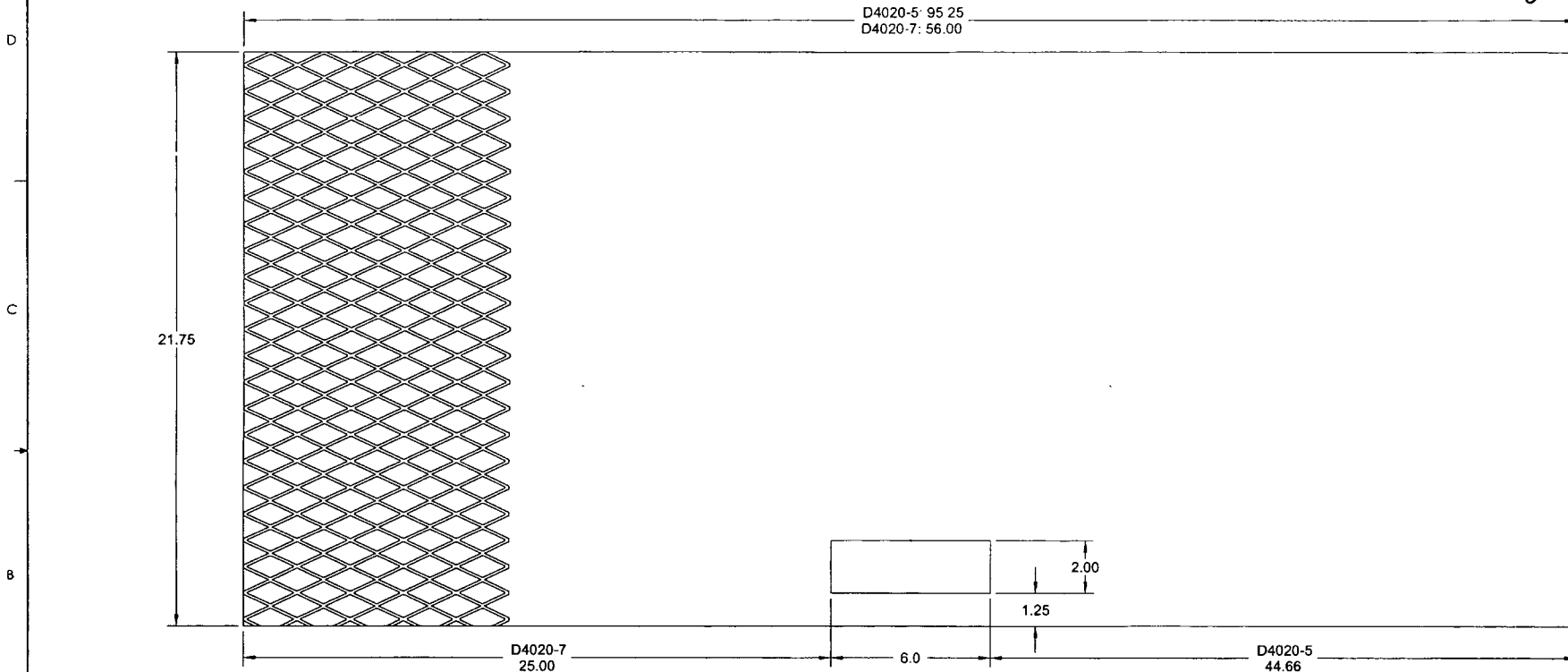
RELEASED
2010-03-12

NOTES:

- 1) MATERIAL-1: MAKE FROM D4020-1F
-3: MAKE FROM D4020-3F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE D4020-1F & D4020-3F
- 8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
- 9) PRE-FORMING OF MESH PER SHOP OPTION, THIS VIEW MAY BE USED FOR REF ONLY

A NEW ISSUE		JPH	10.03.04
REV	DESCRIPTION		BY DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4020	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	350 BASKET MESH (BASE)	NTS
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

85723



9 D4020-5 MESH (350 BASKET LONG, LID)
(LOCAL SECTION MESH SHOWN FOR CLARITY)

9 D4020-7 MESH (350 BASKET SHORT, LID)
(LOCAL SECTION MESH SHOWN FOR CLARITY)

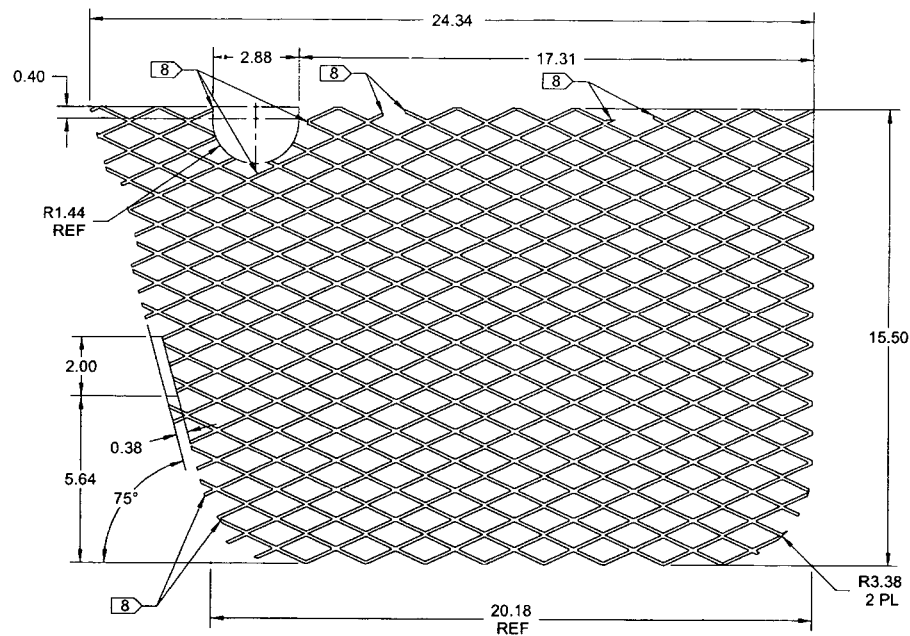
NOTES:

- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -5: 0.80 lbs APPROX
-7: 4.49 lbs APPROX
- 8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
- 9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06 .

RELEASED
2010-03-12
MAD

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4020	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 4	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	350 BASKET MESH (BASE)	NTS
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




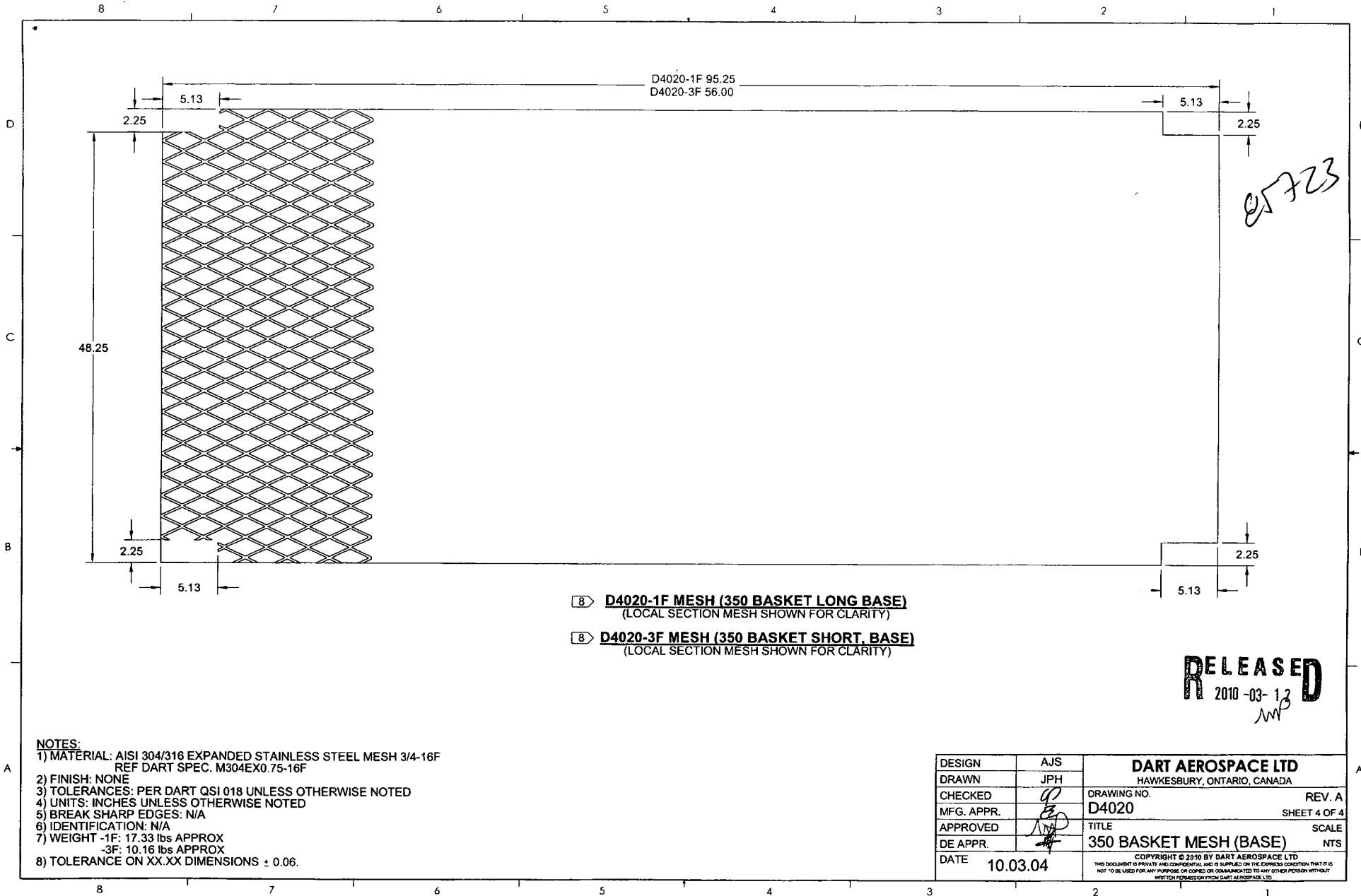
9 D4020-11 END MESH, BASKET

NOTES:

- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.22 lbs
- 8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
- 9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06 .

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DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D4020	SHEET 3 OF 4
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- 8) **D4020-1F MESH (350 BASKET LONG BASE)**
(LOCAL SECTION MESH SHOWN FOR CLARITY)
- 8) **D4020-3F MESH (350 BASKET SHORT, BASE)**
(LOCAL SECTION MESH SHOWN FOR CLARITY)

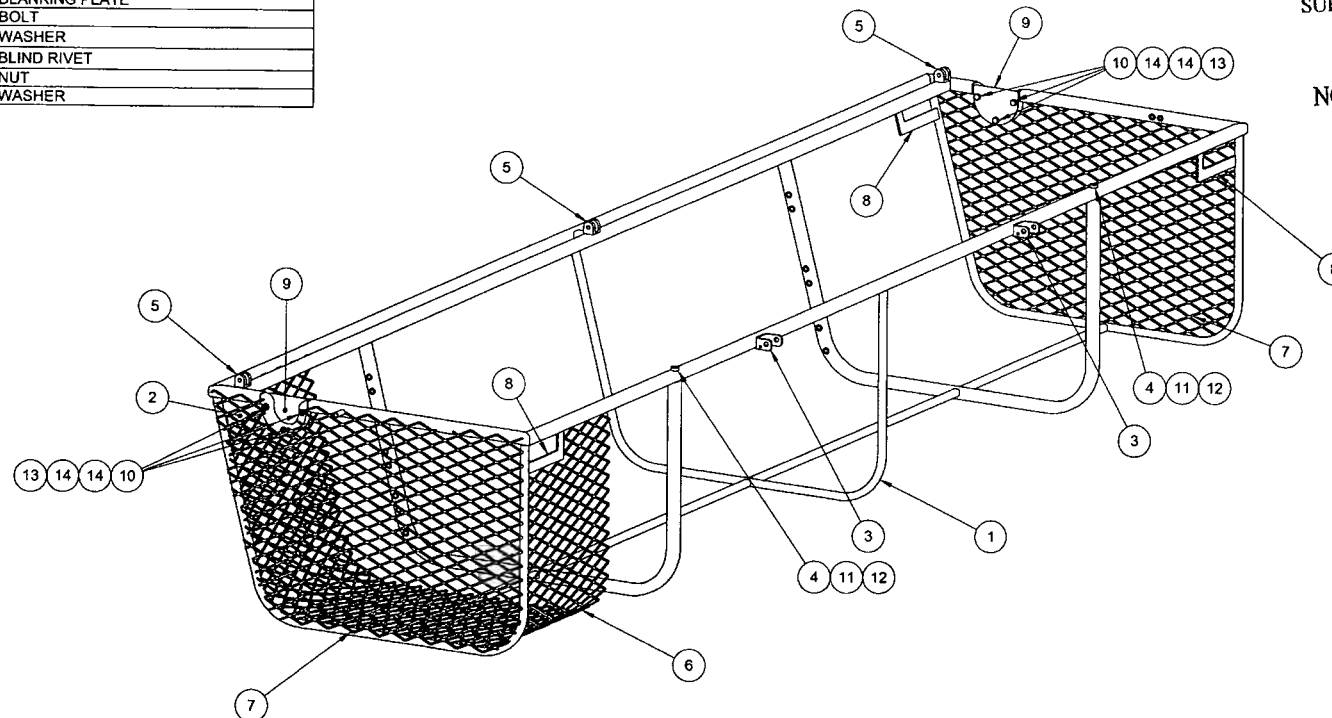
RELEASED
2010-03-13
MB

NOTES:

- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1F: 17.33 lbs APPROX
-3F: 10.16 lbs APPROX
- 8) TOLERANCE ON XX.XX DIMENSIONS ± 0.06 .

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4020	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	350 BASKET MESH (BASE)	NTS
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ITEM	QTY	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	1	D3913-101	TUBULAR ASSY (350 SHORT BASKET)
2	1	D3913-15	WIDE HANDLE PLATE
3	2	D2581	MOUNTING BRACKET
4	2	D2931	BUMPER
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	BLIND RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.3 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 05323 MLJ
12/06/14

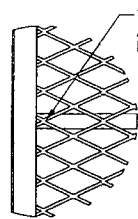
RELEASED
2010-03-22
JPH

A	NEW ISSUE	JPH	10.03.16
REV	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JPH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.03.16		

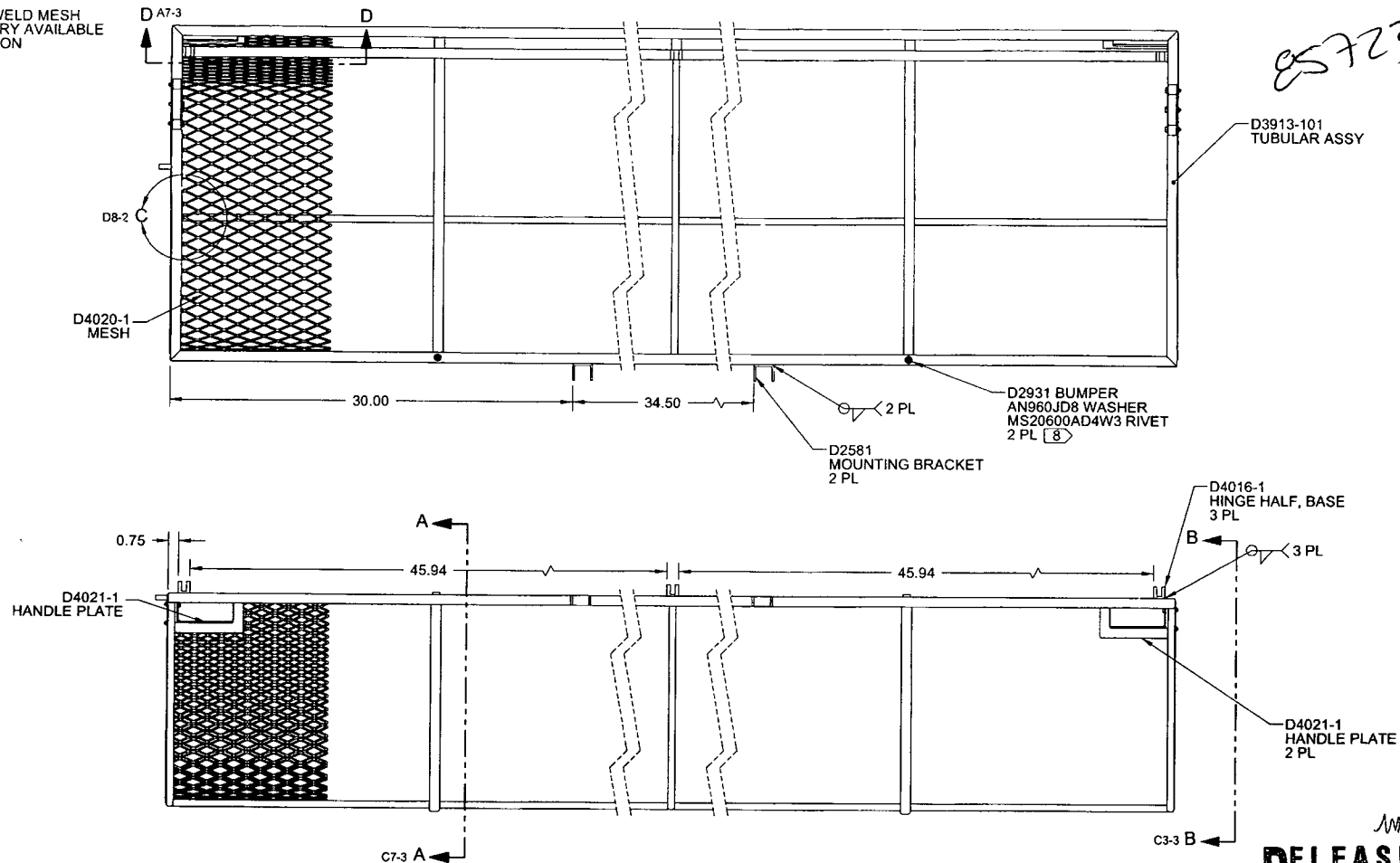
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3913** REV. A
SHEET 1 OF 6
TITLE **LONG BASKET BASE ASSY (350)** SCALE NTS

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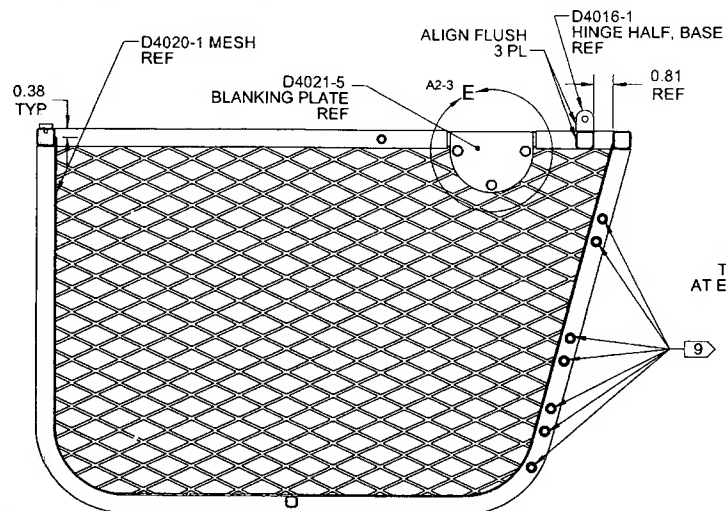
DETAIL C D7-2



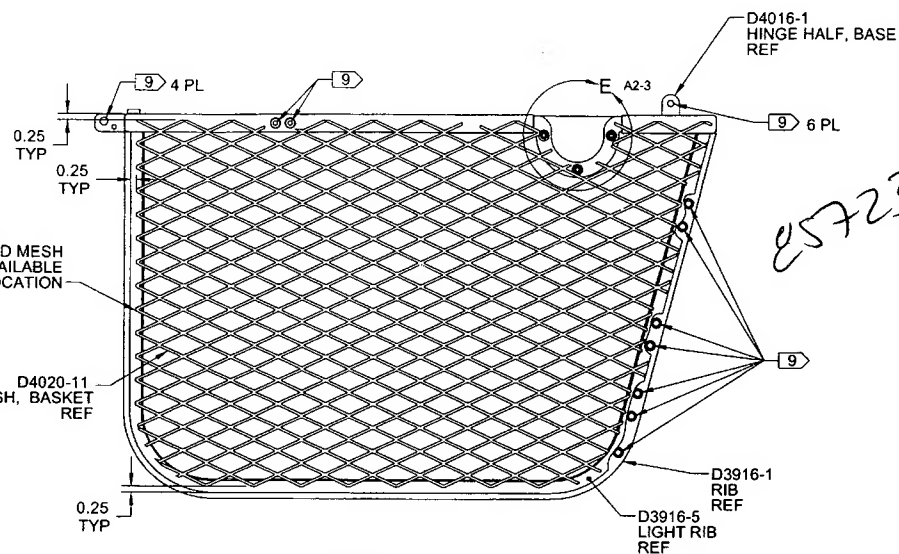
D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

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2010-03-17

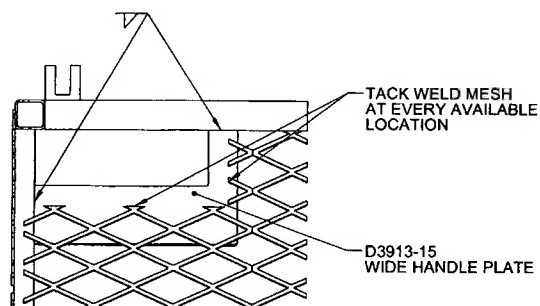
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DRAWN	JRH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO.	REV. A
MFG. APPR.	JS	D3913	SHEET 2 OF 6
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	LONG BASKET BASE ASSY (350) NTS	
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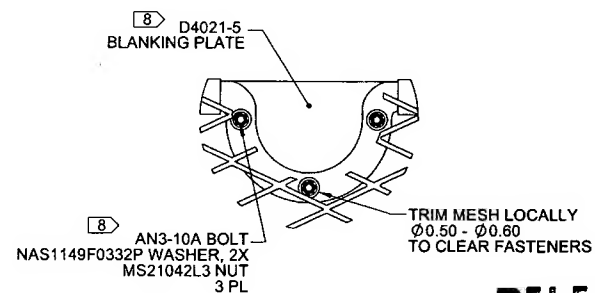
SECTION A-A A5-2



VIEW B-B A2-2



SECTION D-D D7-2
TYPICAL FOR ALL
HANDLE PLATES



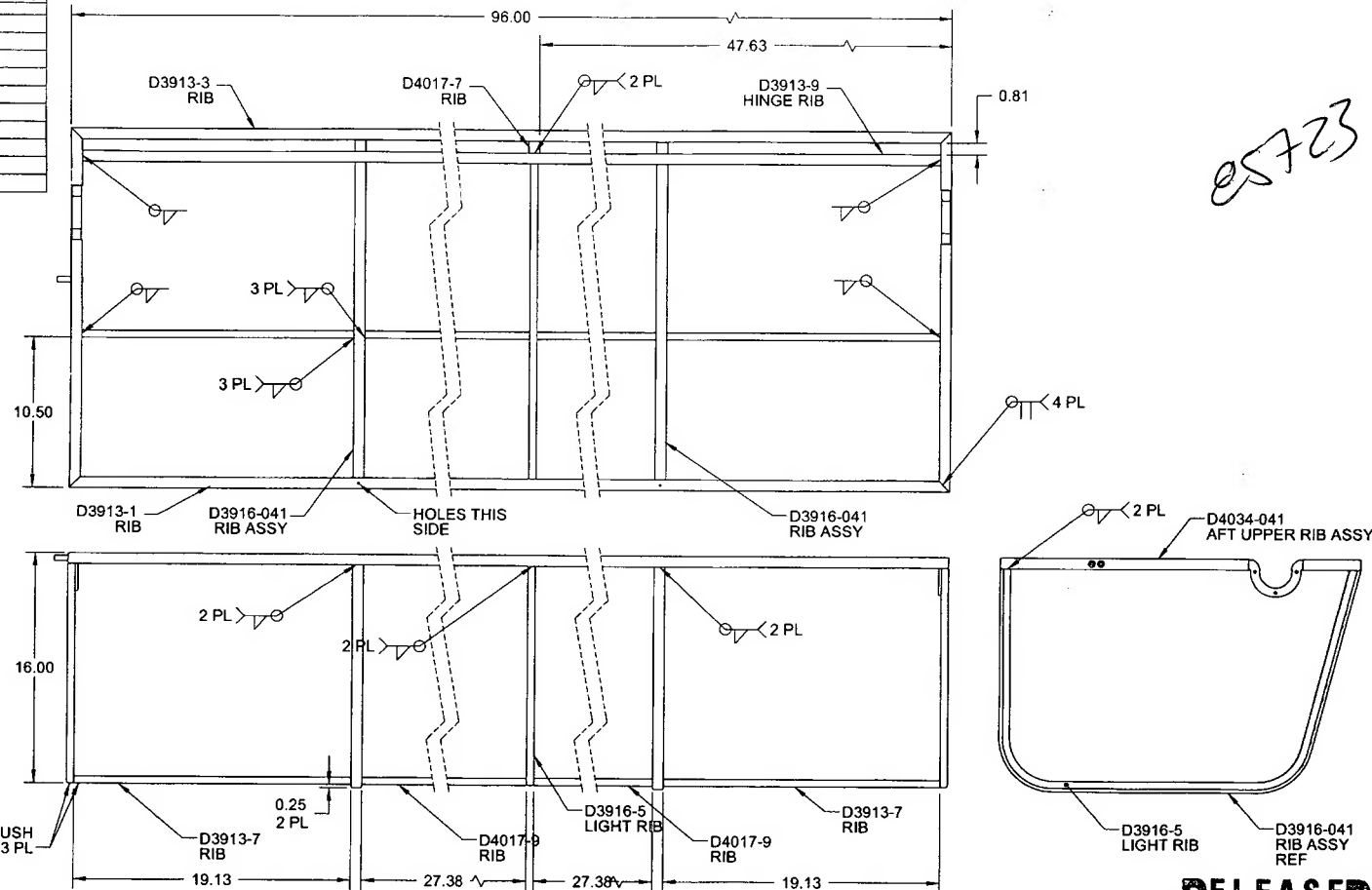
DETAIL D2-3
D6-3

DESIGN	AJS	DART AEROSPACE LTD
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3913
MFG. APPR.		REV. A
APPROVED		TITLE
DE APPR.		SCALE
DATE	10.03.16	LONG BASKET BASE ASSY (350) NTS

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ITEM	QTY	P/N	DESCRIPTION
	X	D3913-101	TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	1	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY



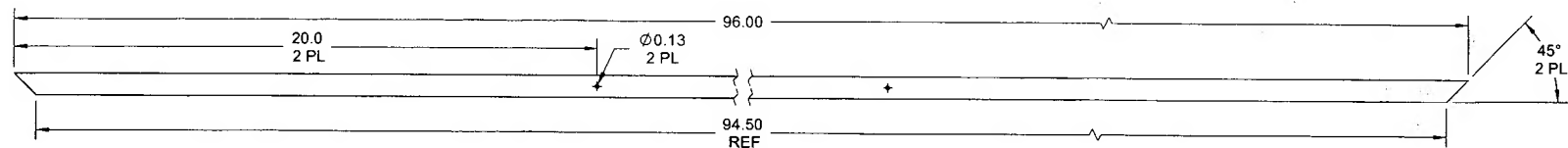
8 D3913-101 TUBULAR ASSY (350 SHORT BASKET)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.53 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D3913-101
- 9) WELD PER DART QSI 004

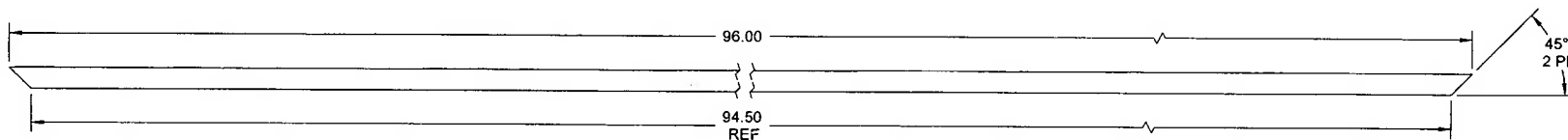
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DRAWN	JRH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 4 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350) NTS	
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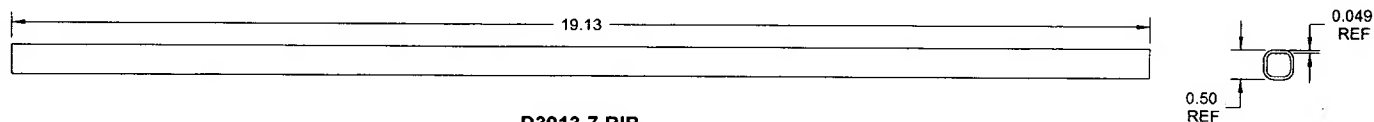


D3913-1 RIB

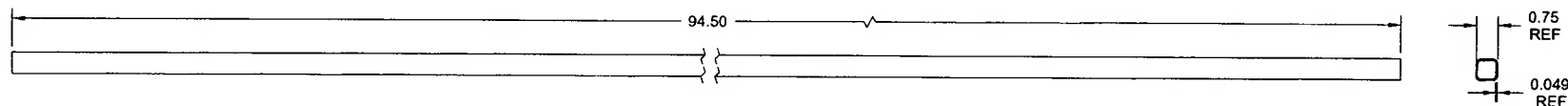
25723



D3913-3 RIB



D3913-7 RIB



D3913-9 HINGE RIB

NOTES:

1) MATERIAL -1, -3, -9: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-7: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED





4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

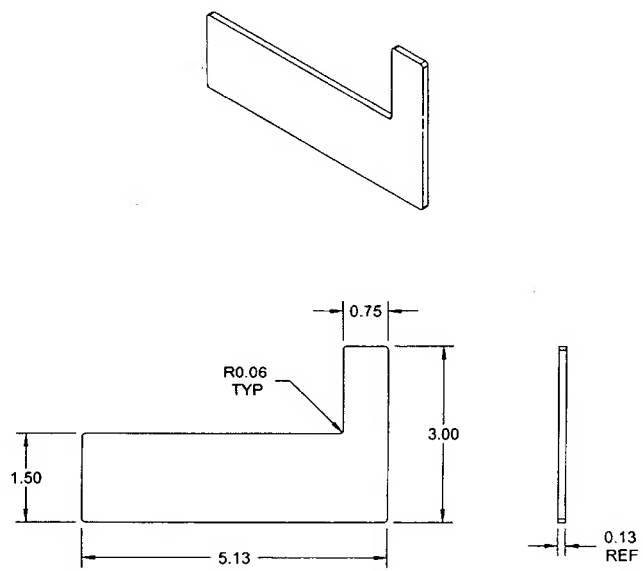
6) IDENTIFICATION: N/A

7) WEIGHT: SEE ASSEMBLED WEIGHTS

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2010-03-22

DESIGN	A/S	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
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05723



D3913-15 WIDE HANDLE PLATE

NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
- 2) FINISH : NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

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DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 6 OF 6
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